

Split

Work Order ID 69124-1

Tuesday, May 03, 2011 9:53:45 AM



Item ID: D4330-2
Revision ID: PRELIM
Item Name: Airframe Bracket

Accept



Setup Start



Stop



Start Date: 5/3/2011 Start Qty: 1.00
Required Date: 5/3/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

PRELIMINARY ISSUE

Reference:

Approvals: Process Plan: *mt* Date: *11-05-03* Tooling:
QC: Date: SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4330	<i>PAT PA9</i>								
100		0.00							
	FLOW WATER JET								
Waterjet		0.00							
FLOW CNC Waterjet	Memo								
<i>666 063</i>	1-Cut as per Dwg (made from D4330-1)								
	Dwg Rev: <i>PAT</i>								
	Prog Rev: <i>PA9</i>								
	2-Deburr if necessary								
110		0.00							
	QC2-Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								
120		0.00							
	QC8-Inspect parts - second check								
QC		0.00							
Quality Control	Memo								

FB11-5-3



FB11-5-3

*ins packed to PAS
dry only
6/10/13*



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Required Date: 5/3/2011 Req'd Qty: 1.00

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Setup Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Bend as per dwg
NC BRAKE

0.00

Memo

0.00

SR 1165103

①

PTO

Brake NC

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/5/4	130.	send 1 flat pattern to calgary. as well	AMF	11/5/4	1	11/05/04 GSI 042.	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/05/04	130	*Sylvie had cut extra pieces because Eric C. told her we needed more. Finally		Scrap - Destroy SPUT W/O. IF IN TWO WEEK NO WORD FROM	8 11/05/04			
		it is ok to send 1 piece finished and 1 flat pattern out to Eagle		EAGLE, SCRAP PARTS.				

NOTE: Date & initial all entries

Tuesday, May 03, 2011 9:53:45 AM



Accept



Setup Start



Stop



Item Name: Airframe Bracket

[illegible]**Cust Item ID:**

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00



Powdercoat

Memo

0.00

Powder Coating

POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

0.00



QC

Memo

0.00

Quality Control

0.00



Packaging

Memo

0,00

Packaging

Work Order ID 69124

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Item ID: D4330-2
Revision ID: PRELIM
Item Name: Airframe Bracket

Accept



Setup Start



Stop



Start Date: 5/3/2011 Start Qty: 1.00
Required Date: 5/3/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

MF 11-09-07

Picklist Print

Tuesday, May 03, 2011 9:53:42 AM

Page 1

Work Order ID: 69124



Parent Item: D4330-2



Parent Item Name: Airframe Bracket



Start Date: 5/3/2011

Required Date: 5/3/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.17 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 		Purchased	No			100	sf	372.0000	0.265	0.278947			
6061-T6 .063 Sheet												B11-5-3	

Location

Loc Qty

Loc Code

MAT021

372

116308

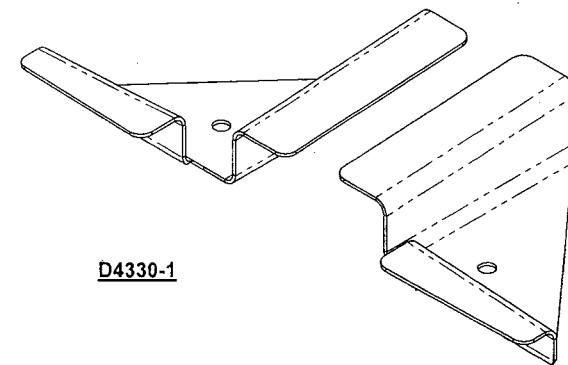
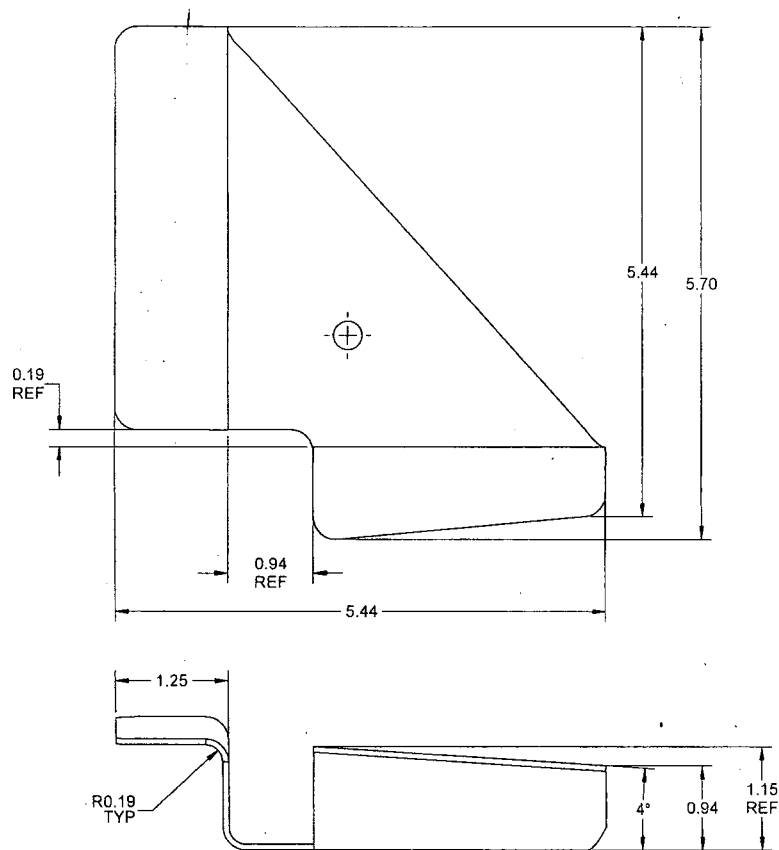
36

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336

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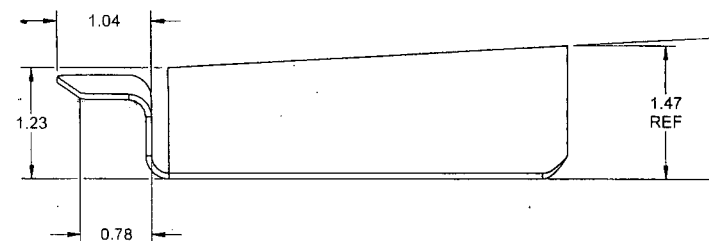




D4330-1

D4330-2

#69124

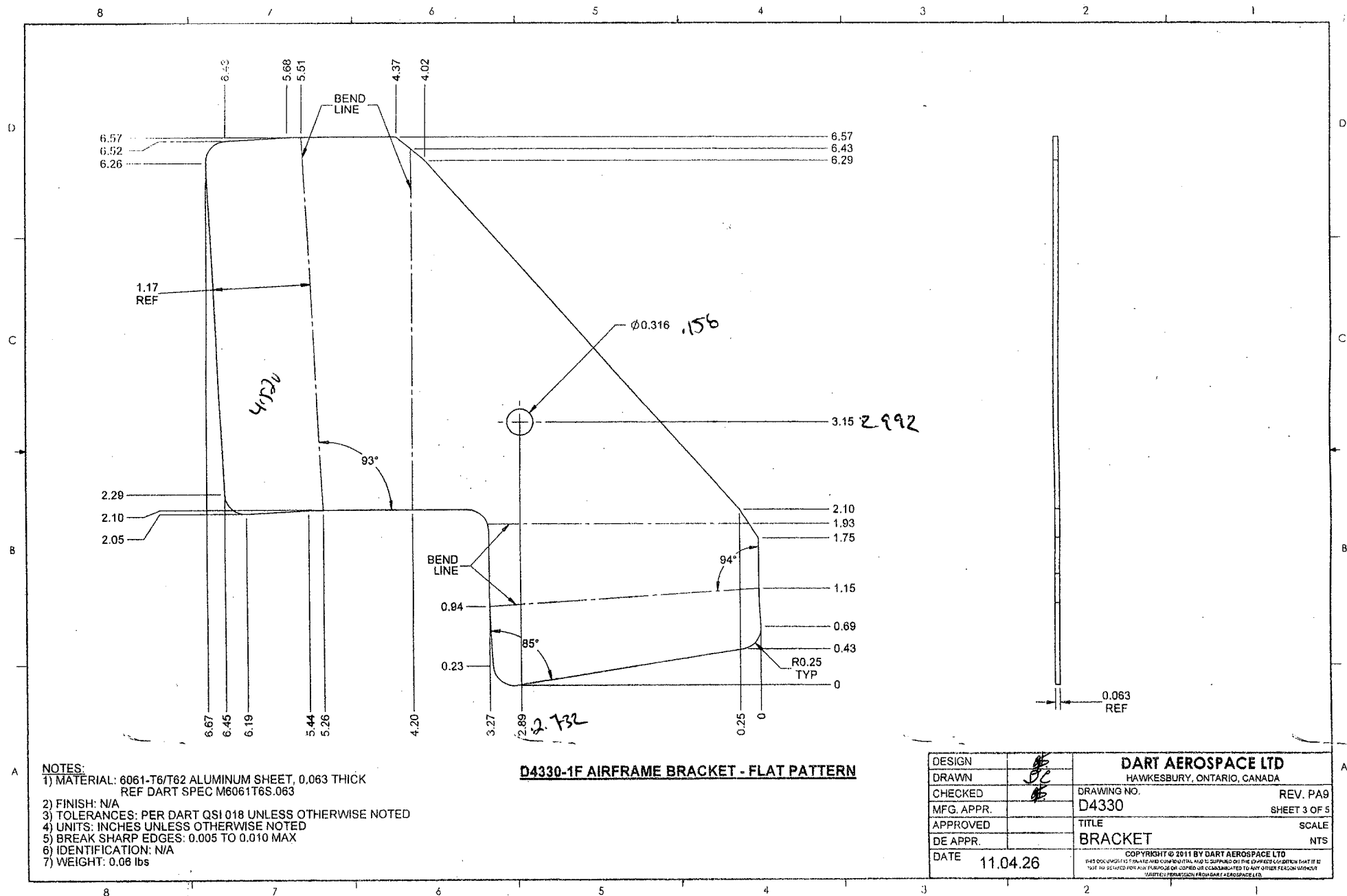


D4330-2 AIRFRAME BRACKET, RH
D4330-1 AIRFRAME BRACKET, LH (OPPOSITE)

NOTES:

- 1) MATERIAL: MADE FROM D4330-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs




DESIGN		DART AEROSPACE LTD	
DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SC</i>	DRAWING NO.	REV. PA9
MFG. APPR.		D4330	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

D4330-1F AIRFRAME BRACKET - FLAT PATTERN

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA9
MFG. APPR.		D4330	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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W/O: 69124-		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.09.01		Scrap parts Westpac one time project will never use these parts again	S	11/09/01	5	Ca 11.09.01	

Part No: D4330-2 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries